

Work Order ID 76515

\*76515\*

Page 1

November-16-11 10:48:45 AM

Item ID: D2596 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Web, 205 Skidtube  
 Start Date: 16/11/2011 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 18/11/2011 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/11/11 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2596    | Rev D        |

|           |   |      |  |  |  |  |  |  |  |
|-----------|---|------|--|--|--|--|--|--|--|
| 100       | Skidtubes                                   | 0.00 |  |  |  |  |  |  |  |
| *100*     | Memo  | 0.00 |  |  |  |  |  |  |  |
| Skidtubes | 1- Cut D2500-3-100 to length: 99.5"         |      |  |  |  |  |  |  |  |
| Skidtubes | 2- Use Jig DT8093 to drill pilot holes #30  |      |  |  |  |  |  |  |  |
|           | 3- Open to 0.630" diameter as per Dwg D2596 |      |  |  |  |  |  |  |  |
|           | 4- Deburr                                   |      |  |  |  |  |  |  |  |

|                |   |      |  |  |  |  |  |  |  |
|----------------|---|------|--|--|--|--|--|--|--|
| 110            | Chemical Conversion Coat per QSI005 4.1 | 0.00 |  |  |  |  |  |  |  |
| *110*          | Memo                                    | 0.00 |  |  |  |  |  |  |  |
| HandFinish     |   |      |  |  |  |  |  |  |  |
| Hand Finishing |   |      |  |  |  |  |  |  |  |

|                 |   |      |  |  |  |  |  |  |  |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120             | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |  |  |  |  |
| *120*           | Memo  | 0.00 |  |  |  |  |  |  |  |
| QC              |   |      |  |  |  |  |  |  |  |
| Quality Control |   |      |  |  |  |  |  |  |  |

2. 0 BE11-11-16

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 76515****\*76515\***

Page 2

November-16-11 10:48:45 AM

Item ID: D2596 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Web, 205 Skidtube  
Start Date: 16/11/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 18/11/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp           |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------------|
| 130                            | Identify as per dwg & Stock Location: <u>LG</u> | 0.00                 |         |        |              |               |               |                  |                          |
| <b>*130*</b>                   |   |                      |         |        |              | <u>2</u>      | <u>0</u>      | <u>3E1H1/6</u>   |                          |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                          |
| Packaging                      |   |                      |         |        |              |               |               |                  |                          |
| 140                            | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  |                          |
| <b>*140*</b>                   |   |                      |         |        |              |               |               |                  | <u>11/11/17</u> <u>2</u> |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                          |
| Quality Control                |   |                      |         |        |              |               |               |                  |                          |

11-11-17  
(2)

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

November-16-11 10:48:49 AM

Page 1

Work Order ID: 76515

**\*76515\***

Parent Item: D2596

**\*D2596\***

Parent Item Name: Web, 205 Skidtube

Start Date: 16/11/2011

Required Date: 18/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM  
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2500-3-100                     |                        | Manufactured  | No          |                     |                  | 100             | Each               | 78.0000        | 1           | 2            |               |                |        |
| <b>*D2500-3-100*</b>            |                        |               |             |                     |                  |                 |                    |                | <b>**</b>   |              |               |                |        |

Ext'n -'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

78

51957

2

66298

76

ATW

②

11-11-16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

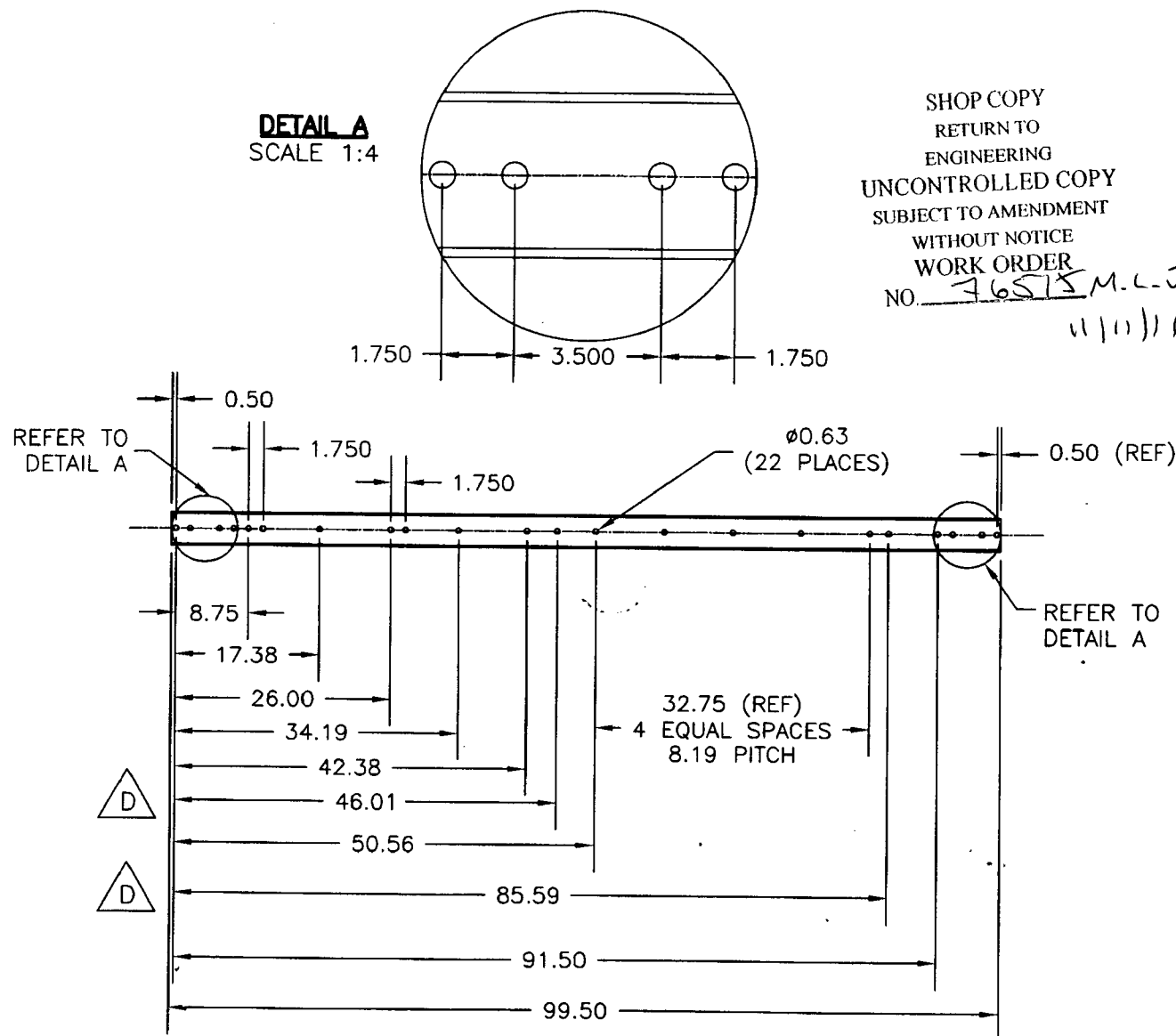
**NOTE:** Date & initial all entries



RELEASED  
07.06.28

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76515 M.L.J  
11/11/16

**DETAIL A**  
SCALE 1:4



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

| DESIGN   | DRAWN BY | DART AEROSPACE LTD               |         |              |
|----------|----------|----------------------------------|---------|--------------|
| 04       | 04       | HAMKESBURY, ONTARIO, CANADA      |         |              |
| CHECKED  | APPROVED | DRAWING NO.                      | REV. D  | SHEET 1 OF 1 |
| 07.04.17 | 07.04.17 | D2596                            | 205 WEB | SCALE 1:20   |
| A        | 96.09.16 | NEW ISSUE                        |         |              |
| B        | 97.07.23 | $\phi 0.63$ HOLE WAS $\phi 0.56$ |         |              |
| C        | 98.09.14 | INCORPORATED DEO 9097            |         |              |
| D        | 07.04.17 | INCORPORATED DEO 9183            |         |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries